



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D206-642-251
Job Sheet 199302



Part No: D206-642-251

Job Qty: 1 pcs

Part Name: Replacement Skidtube, High Gear with Run-on Landing Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/16/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 9/3/19

Description:

Note: DWG D3804 REV A (DEO), IIN-D206-642 REV Q SHEETS 13,28 IPP REV:A 11.11.17 PER IIN REVO DD
VERF;EC IPP Rev:B 12.11.22 now swage per ecn12-679 DD verf:JLM IPP Rev:C 14.04.25 Ecn14-520 DD
verf:JLM IPP Rev:D 16.04.04 as per CHG004(ecn16-553) DD verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	9/3/19		0.00	3.00	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
120	QC 5	1 pcs	9/3/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
							QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
130	QC 9	1 pcs	9/3/19		0.00	0.00			



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S208093



Part: D206-642-251

Job No: 199302

Serial No/Batch: S208093

Revision:

Inspector:

Exp Date:

Instructions: FAA STC SADO475SE 18/10/17, STC SH98-

PRIORITY

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AUG 22 2019 50

0.80

3EB19-08-23

140 Handfinish - 1-1 Chemical- B4B

1
pcs

9/3/19

0.00 1.05

QC 9 - 50

QC 9 - 9

Handfinish - 1 - 1 - B4B

Handfinish - 1 - 2 - B4B

Handfinish - 1 - 3 - B4B

Handfinish - 1 - 4 - B4B

Handfinish - 1 - 5 - B4B

Handfinish - 1 - 6 - B4B

Handfinish - 1 - 7 - B4B

Handfinish - 1 - 8 - B4B

Handfinish - 1 - 9 - B4B

Handfinish - 1 - 10 -
B4BHandfinish - 1 - 11 -
B4BHandfinish - 1 - 12 -
B4BHandfinish - 1 - 13 -
B4BHandfinish - 1 - 14 -
B4BHandfinish - 1 - 15 -
B4BHandfinish - 1 - 16 -
B4BHandfinish - 1 - 17 -
B4BHandfinish - 1 - 18 -
B4BHandfinish - 1 - 19 -
B4BHandfinish - 1 - 20 -
B4BHandfinish - 1 - 21 -
B4BHandfinish - 1 - 22 -
B4B

150 QC 7

1
pcs

9/3/19

0.00 0.00

QC 7 - 10

QC 7 - 13

QC 7 - 14

QC 7 - 15

QC 7 - 17

QC 7 - 18

QC 7 - 19

QC 7 - 2

QC 7 - 28

QC 7 - 3

QC 7 - 30

QC 7 - 34

QC 7 - 36

QC 7 - 37

QC 7 - 41

QC 7 - 47

QC 7 - 48

QC 7 - 51

QC 7 - 58

QC 7 - 59

QC 7 - 60

QC 7 - 9

QC 7 - 68

QC 7 - 50

					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
160 Skidtubes - 2 - B4B	1 pcs	9/3/19	0.00 3.38	Skidtubes - 1 - B4B		DN
				Skidtubes - 2 - B4B		
				Skidtubes - 3 - B4B		
				Skidtubes - 4 - B4B		
				Skidtubes - 5 - B4B		
				Skidtubes - 6 - B4B		
				Skidtubes - 7 - B4B		
180 Skidtubes - 3 - B4B	1 pcs	9/3/19	0.00 3.38	Skidtubes - 1 - B4B		DN
				Skidtubes - 2 - B4B		
				Skidtubes - 3 - B4B		
				Skidtubes - 4 - B4B		
				Skidtubes - 5 - B4B		
				Skidtubes - 6 - B4B		
				Skidtubes - 7 - B4B		
190 QC 5	1 pcs	9/3/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		BE
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		
				QC 5 - 9		
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40		
				QC 5 - 61		
				QC 5 - 81		
200 Skidtubes - 4 - B4B	1 pcs	9/3/19	0.00 3.38	Skidtubes - 1 - B4B		
				Skidtubes - 2 - B4B		
				Skidtubes - 3 - B4B		
				Skidtubes - 4 - B4B		TF
				Skidtubes - 5 - B4B		BE
				Skidtubes - 6 - B4B		
				Skidtubes - 7 - B4B		
220 QC 9	1 pcs	9/3/19	0.00 0.00	QC 9 - 10		
				QC 9 - 18		
				QC 9 - 24		
				QC 9 - 43		
				QC 9 - 50		
				QC 9 - 9		
230 QC 5	1 pcs	9/3/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		

					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	SEP 18 2019 DAS 68 9-89
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
240 Handfinish - 2-1 Pressure- B4B	1 pcs	9/3/19	0.00 1.05		Handfinish - 2 - 1 - B4B	
					Handfinish - 2 - 2 - B4B	SEP 18 2019
					Handfinish - 2 - 3 - B4B	
					Handfinish - 2 - 4 - B4B	
250 Powdercoat - 1 White SI(A)- B4B	1 pcs	9/3/19	0.00 0.22		Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	DL 14-9-19
					Powdercoat - 4 - B4B	
260 QC 3	1 pcs	9/3/19	0.00 0.00		QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	DL 14-9-19
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
270 Handfinish - 4-1-Assembly-B4B	1 pcs	9/3/19	0.00 1.05		QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
					Handfinish - 4 - 1 - B4B	DL 14-9-19
					Handfinish - 4 - 10 - B4B	
					Handfinish - 4 - 11 - B4B	
					Handfinish - 4 - 12 - B4B	
					Handfinish - 4 - 13 - B4B	
					Handfinish - 4 - 14 - B4B	
					Handfinish - 4 - 15 - B4B	
					Handfinish - 4 - 2 - B4B	
					Handfinish - 4 - 3 - B4B	
					Handfinish - 4 - 4 - B4B	
					Handfinish - 4 - 5 - B4B	

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280 Handfinish - 4-2-Assembly-B4B	1 pcs	9/3/19	0.00 3.14	Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
				Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	del 19-9-16
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
290 QC 3 WA AK	1 pcs	9/3/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
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				QC 5 - 24	
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				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
300 QC 5	1 pcs	9/3/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
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				QC 5 - 19	
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				QC 5 - 24	
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				QC 5 - 43	
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				QC 5 - 51	
				QC 5 - 58	

					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	DAS SEP 20 2019 40
					QC 5 - 61	9-89
					QC 5 - 81	
310	Packaging 3-1 - Stock - B4B	1	9/3/19	0.00 0.00	Packaging 3 - 1 - B4B	
	pcs				Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	DAS 21 SEP 20 2019 9-89
315	DC - 1 - B4B	1	9/3/19	0.00 0.00	DC - 1 - B4B	
	pcs				DC - 2 - B4B	
320	QC 21 - FG	1	9/3/19	0.00 0.00	QC 21 - FG - 21	DAS 21 SEP 20 2019 9-89
	pcs				QC 21 - FG - 70	
Part Op 110 - Skidtubes - 1-Deburr Fwd edge of tube 2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804 3-Weld Descriptions: Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required. Pick: Qty Part Number Description Batch A/R Aluminum Rod 13961/13961 4-Grind weld flush to cap on top surface only. 5-Cut Aft end as per dwg D3804 from front of tube and Deburr 6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804 7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025. 8-Drill pilot holes using Dt 8167, including #30 pilot at 1.25" from 15.450". Most fwd x-bolt hole must be laid out manually at 78.04". 9-Locate DT8732A from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732B & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732A & doubler leaving DT8732B for added support. 10- Drill D3286-1 doubler rivet holes in tube using # 40 drill, spot drilling doubler at the s 120 - QC5- Inspect part completeness to step on W/O 130 - QC9- Inspect visual per QSI004- Fusion Welds 140 - Chemical Conversion Coat per QSI005 4.1 150 - QC7-Inspect Chemical Conversion Coat 160 - Skidtubes 1-Open holes to finished size to detail "B" as per Dwg D3804, (without cutting fluid) 2-C'sink ONE crossbolt spacer hole as per Dwg D3804 (Detail B)(without cutting fluid) 3-Deburr and blow out all chips from inside the						

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tube

180 - Skid tubes - 1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required 2-Bond D2654-3 web in place as per QSI 015; Ensure holes line up. Allow 12 Hrs. cure time before cutting Start Date: _____ Time: _____
 Finish Date: _____ Time: _____ Pick: Qty Part Number Description Batch A/R Sikaflex-291

Sikaflex expire date: 5200625 07/25/2020
 190 - QC5- Inspect part completeness to step on W/O

200 - Skid tubes 1-Remove alodine per DEO detail B from around hole and prepare for welding 2-Prep per QSI 005 and Insert one D2649 crossbolt spacer. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod. Pick: Qty Part Number Description Batch A/R Aluminum Rod

138189 3-Grind welds flush as per Dwg D3804. 4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required. A/R SS Rod N/A 5-Insert D4720-1 Spacer. Swage to 0.313" X 0.75" DP per QSI 002. Trim and grind flush per QSI 002 6- Debur

220 - QC9- Inspect visual per QSI004- Fusion Welds

230 - QC5- Inspect part completeness to step on W/O

240 - Pressure Wash per QSI005 4.3/ Clean and remove all markings

250 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs. START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

260 - QC3- Inspect Part Finish

270 - HandFinish4 (Assemble as per dwg 1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive. 2- Install D2680-041 Nut Plate as per Dwg D2650

280 - HandFinish4 (Assemble as per dwg -1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive A/R Sikaflex-291 5204135 Sikaflex expire date: 20-7-2020 2- Install wearplate as per dwg 2-Wing Walk as per Dwg D3804 and QSI 005 4.4 Batch: 520936

290 - QC3- Inspect Part Finish

300 - QC5- Inspect part completeness to step on W/O

310 - Identify and pack for shipping as per PPP D206-642-251 Location: _____ PPP Rev: _____

315 - Document Control Photocopy bluefile & type labels per PPP D206-642-251 CHG004

320 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2620	Skid tube, 206 Skid tube	1 pcs (1 ea)	110-Skid tubes - 1	5189572
D2647	Cap	1 pcs (1 ea)	110-Skid tubes - 1	5166098
D3286-1	Doubler	2 pcs (2 ea)	110-Skid tubes - 1	517617
CR3212-4-04	Cherry Rivet	61 52 Ea (52 ea)	200-Skid tubes - 4 - B4B	5161493
D2649	Cross Bolt Spacer	1 pcs (1 ea)	200-Skid tubes - 4 - B4B	5199364
D2654-3	Web	1 pcs (1 ea)	200-Skid tubes - 4 - B4B	5167131
D3286-3	Spacer	2 pcs (2 ea)	200-Skid tubes - 4 - B4B	5173052
D4720-1	Spacer	20 19 pcs (19 ea)	200-Skid tubes - 4 - B4B	524318
AN3-37A	Bolt	7 Ea (7 ea)	270-Handfinish - 4-1-Assembly-B4B	5210642
CR3212-4-03	Cherry Rivet	2 Ea (2 ea)	270-Handfinish - 4-1-Assembly-B4B	519612
D2651-1	Plug	8 pcs (8 ea)	270-Handfinish - 4-1-Assembly-B4B	5196044
D2651-3	O-Ring	8 pcs (8 ea)	270-Handfinish - 4-1-Assembly-B4B	5180320
D2680-041	Nut Plate	1 pcs (1 ea)	270-Handfinish - 4-1-Assembly-B4B	5197610
D3805-043	Run-on Landing Wearplate Fwd	1 pcs (1 ea)	270-Handfinish - 4-1-Assembly-B4B	5008356
D3805-047	Run-on Landing Wearplate Aft	1 pcs (1 ea)	270-Handfinish - 4-1-Assembly-B4B	5205666
D3873-1	Bushing	14 pcs (14 ea)	270-Handfinish - 4-1-Assembly-B4B	5209430
MS21042L3	Nut	7 Ea (7 ea)	270-Handfinish - 4-1-Assembly-B4B	5204283-2
MS27039-1-08	Screw	2 Ea (2 ea)	270-Handfinish - 4-1-Assembly-B4B	5162897
MS27039-4-06	Screw	1 Ea (1 ea)	270-Handfinish - 4-1-Assembly-B4B	5166971
NAS1149C0332R	Washer (AN960C10L)	7 Ea (7 ea)	270-Handfinish - 4-1-Assembly-B4B	5193136
NAS1149D0332J	Washer	2 Ea (2 ea)	270-Handfinish - 4-1-Assembly-B4B	5178378
NAS1149D0463J	Washer	1 Ea (1 ea)	270-Handfinish - 4-1-Assembly-B4B	515058
CCR264SS3-3	Cherry Rivet	2 Ea (2 ea)	270-Handfinish - 4-1-Assembly-B4B	5099373
D2646	Aft Cap	1 pcs (1 ea)	280-Handfinish - 4-2-Assembly-B4B	5160607

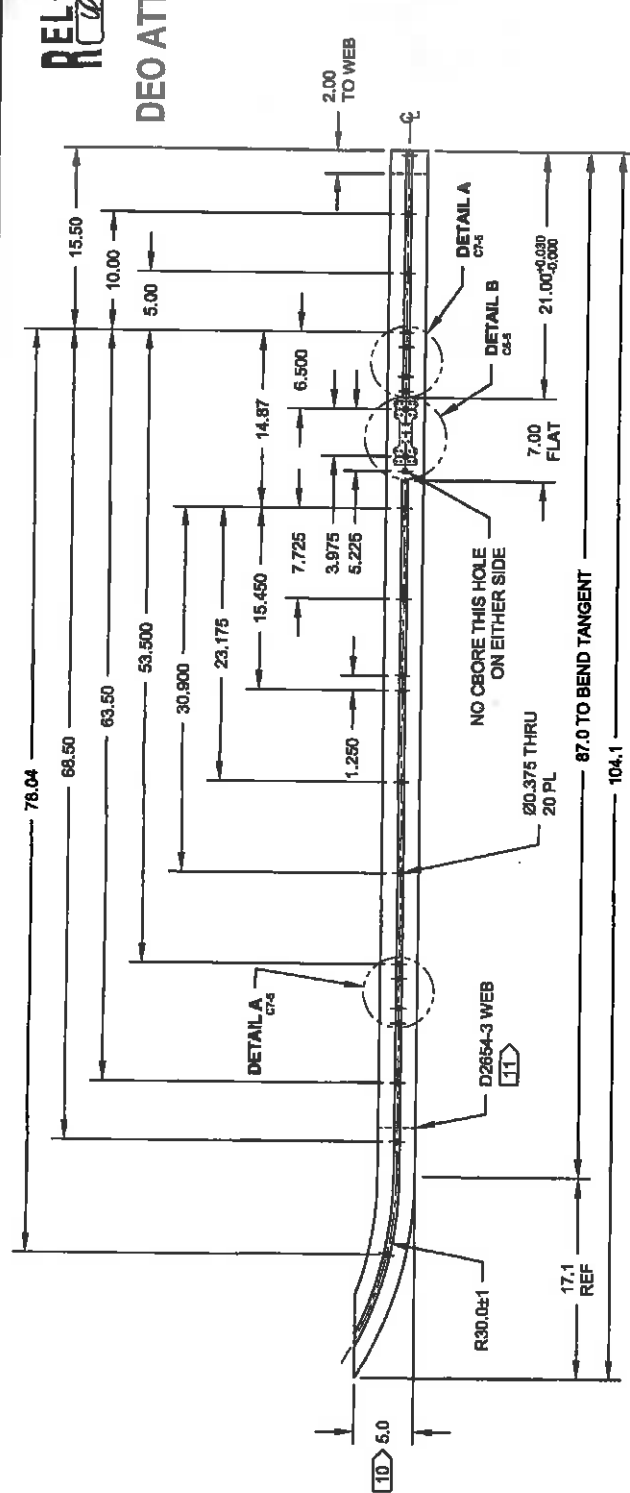
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2620	1	5	0
	D2647	1	30	0
	D3286-1	2	24	0
200-Skidtubes - 4 - B4B	CR3212-4-04	52	313	0
	D2649	1	31	0
	D2654-3	1	6	0
	D3286-3	2	8	0
	D4720-1	19	20	0
	AN3-37A	7	77	0
270-Handfinish - 4-1-Assembly-B4B	CCR264SS3-3	2	81	0
	CR3212-4-03	2	60	0
	D2651-1	8	305	0
	D2651-3	8	723	0
	D2680-041	1	32	0
	D3805-043	1	1	0
	D3805-047	1	1	0
	D3873-1	14	0	0
	MS21042L3	7	1,886	0
	MS27039-1-08	2	411	0
	MS27039-4-06	1	86	0
	NAS1149C0332R	7	2,894	0
	NAS1149D0332J	2	2,223	0
	NAS1149D0463J	1	3,760	0
	D2646	1	67	0
Part Specifications				
Specifications could not be found.				

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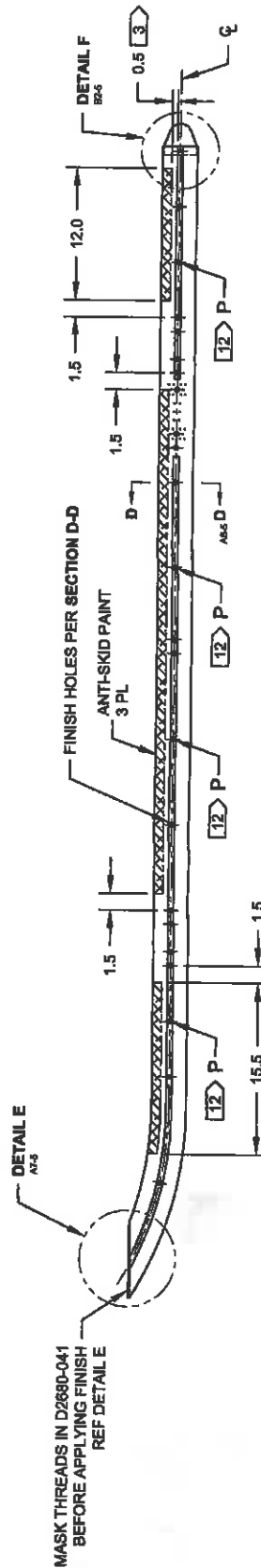
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R 10 09.12.23

DEO ATTACHED

1 2 3 4 5 6 7 8



D3804-043 BENDING/DRILLING DETAIL



D3804-043 ASSEMBLY/FINISHING DETAIL

DESIGN	41	DART AEROSPACE USA, INC
DRAWN	41	PORT HADLOCK, WA
CHECKED	41	REV. A
MFG. APPR.	41	DRAWING NO. D3804
APPROVED	41	SHEET 3 OF 5
DE APPR.	41	TITLE SKIDTUBE ASSEMBLY, 206A/B
DATE	08.07.07	SCALE NTS

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1 2 3 4 5 6 7 8

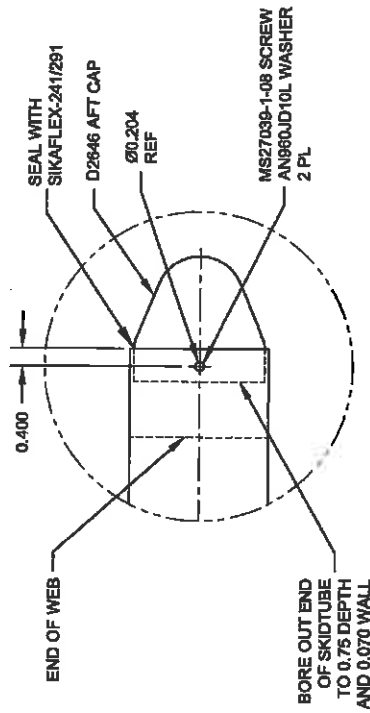
RELEASED

DEO ATTACHED

CR3212-4-03 RIVET
2 PL

CCR264SS3-3
RIVET
2 PL

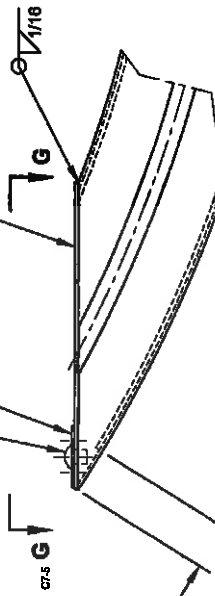
VIEW G-G
SCALE NONE



DETAIL F
SCALE NONE

- D2847 CAP. TO INSTALL:
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D2847 (TRIM AS REQD)
 4. WELD D2847 IN PLACE
 5. GRIND FLUSH
 6. RIVET D2880-041 NUT PLATE IN PLACE

MS27039-4-06 SCREW
AN860JD16 WASHER
D2880-041
NUT PLATE



DETAIL E
SCALE NONE

DESIGN	11	DART AEROSPACE USA, INC
DRAWN	11	PORT HADLOCK, WA
CHECKED	11	DRAWING NO.
MFG. APPR.	11	D3804
APPROVED	11	TITLE
DE APPR.	11	SKITUBE ASSEMBLY, 206A/B
DATE	08.07.07	SCALE
		NTS

REVISIONS
REV. A
SHEET 5 OF 5
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SYSTEM.

Job: _____ Part No. _____		DISPOSITION Rework Scrap Use-as-is		DEPARTMENT/PROCESS Skid-tube Machining Large Fab Cross tube Small Fab Finishing Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging Engineering Water Jet Supplier Quality				MRB (QSI042)	
Date : _____		Sequence #: _____		QTY Affected : _____					
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor	
								QC / QA Coordinator	

Root Cause		FAULT CATEGORY									
Operator		Pressure/Forced		Contamination		Power Loss/Surge		Positioned Wrong			
Manufacturing Process		Bending		Misaligned/off center		Folio/Program		Outside Tolerance			
Equip/Tooling		Crushing		BOM/Route		Grain Direction		Drawing			
Handling/Preservation		Cracks		Broken/Damage/Defect		Weld		Finish			
Material		Crimp/Kink/Ripple/Wave/Twist		Incomplete/Unclear Instructions		Wrong Stock Pulled		Part Lost/Missing			
Product Improvement		Marks/Chatter		Drill Holes		Out of Sequence		Misread			
Process Improvement		Mislabeled		Fit/Function		Off-set/Set-up					
Human Factors		Other/Details:									